

Work Order ID 81510-1

March-15-12 8:09:55 AM

81510

Page 1

Item ID: D412-666-011

Revision ID:

Item Name: Gross Weight Towing

Start Date: 15/03/2012 Start Qty: 2.00

Required Date: 29/03/2012 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *12-1*

QC:

Date: *12/04/13* Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-666

Rev C1

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP412-666-011

CHG 004 *JB*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

8/26/13

(A)

12/04/13 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81510

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81510

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Item ID: D412-666-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gross Weight Towing

Start Date: 15/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D412-666-011 Location:

PPP Rev: 





140

QC21- Final Inspection - Work Order Release

0.00

140

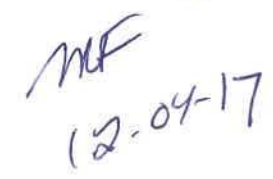
QC

Memo

0.00

Quality Control





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

March-15-12 8:09:58 AM

Work Order ID: 81510

Parent Item: D412-666-011

Parent Item Name: Gross Weight Towing

81510

D412-666-011

Start Date: 15/03/2012

Start Qty: 2.00

Required Date: 29/03/2012

Required Qty: 2.00

Comments: IPP Rev:B Added GHG 002 NG 02-03-06
IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN6-15A Purchased No

AN6-15A

Bolt

Location

ST341

Loc Qty

138

Loc Code

117795

13

120423

125

110

Each

68.0000

4

8

**

AN6-45A Purchased No

AN6-45A

Bolt

Location

ST343

Loc Qty

68

Loc Code

120187

18

120423

50

110

Each

0.0000

8

16

**

AN960ID616 NAS1149D0663J Purchased No

AN960.ID616

Washer

D2888

Manufactured No

D2888

Lug

Location

ST485

Loc Qty

6

Loc Code

77934

6

110

Each

6.0000

2

4

**

1/2

JB

JB

JB

JB

JB

12/04/13

B 81051 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81510

81510

Parent Item: D412-666-011

D412-666-011

Parent Item Name: Gross Weight Towing

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS2104216

Purchased

No

110

Each

934.0000

4

8

**

MS2104216

Nut

Location

Loc Qty

Loc Code

ST300

934

117677

25

118384

3

118927

48

119075

658

120308

200

119075

JB

12/04/13

March-15-12 8:09:58 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

REFERENCE ONLY

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

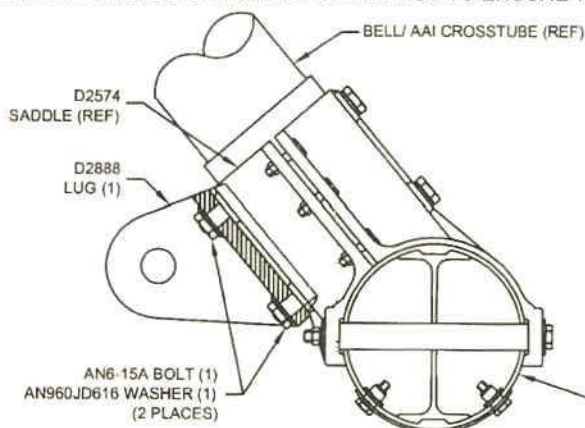


FIGURE 1
(BELL/AAI CROSSTUBES)

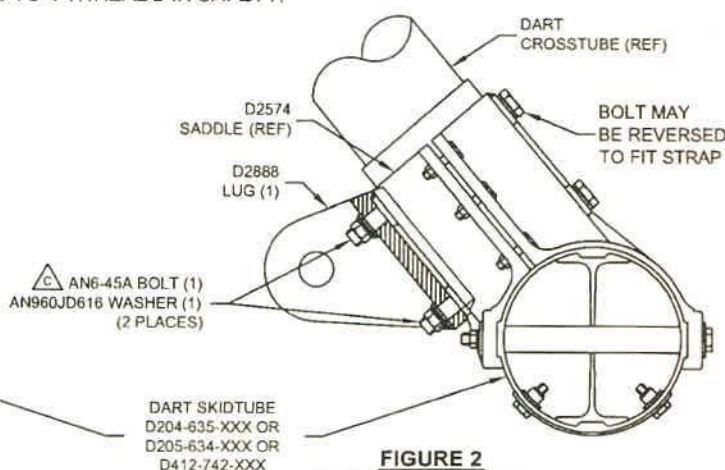


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-666	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		412 GROSS WEIGHT TOWING KIT	1:4
DATE	07.08.10	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B OR LATER APPROVED REVISION

REF. TCCA STC: SH96-88
REF. FAA STC: SR00563NY
REF. EASA IM.R.S.01303
REF. JAPANESE STC: STC-55-1-TYO

REFERENCE ONLY

THE FOLLOWING OPTIONAL KITS MAY BE PURCHASED FROM DART AEROSPACE AND ARE APPROVED FOR INSTALLATION ON DART D205-634-XXX SKIDTUBES

KIT	DESCRIPTION	INSTALLATION INSTRUCTIONS	PURPOSE
D205-665-011	CABLE GUARD KIT	D205-665 REV. F OR LATER APPROVED REVISION	TO PROTECT THE SKIDTUBES FROM DAMAGE FROM HOIST KIT CABLES
D205-665-013	CABLE GUARD KIT	D205-665 REV. F OR LATER APPROVED REVISION	TO PROTECT THE SKIDTUBES FROM DAMAGE FROM HOIST KIT CABLES
D205-665-015	CABLE GUARD KIT	D205-665 REV. F OR LATER APPROVED REVISION	TO PROTECT THE SKIDTUBES FROM DAMAGE FROM HOIST KIT CABLES
D205-665-017	CABLE GUARD KIT	D205-665 REV. F OR LATER APPROVED REVISION	TO PROTECT THE SKIDTUBES FROM DAMAGE FROM HOIST KIT CABLES
D205-665-019	CABLE GUARD KIT	D205-665 REV. F OR LATER APPROVED REVISION	TO PROTECT THE SKIDTUBES FROM DAMAGE FROM HOIST KIT CABLES
D412-666-011	GROSS WEIGHT TOWING KIT	D412-666 REV. C OR LATER APPROVED REVISION	TO ALLOW FOR GROSS WEIGHT TOWING OF THE AIRCRAFT IN ACCORDANCE WITH BHT-412-SI-58
D412-673-011	ELECTRIC STEP ADAPTATION KIT	D412-673 REV. C OR LATER APPROVED REVISION	TO ALLOW INSTALLATION OF BELL 212-706-105-003 ELECTRIC RETRACTING STEPS

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.31
CERT. NO.: SH96-88
ISSUE NO.: 3

E	ADD D205-665-019	RF	11.10.31
D	ADD D205-665-011/-013	CP	09.11.12
C	ADD D205-665-017; REFORMAT	HS	09.09.08
B	ADD D412-673-011	CP	99.10.01
A	NEW ISSUE	CP	99.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9152	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL SKIDTUBE KITS	NTS
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